

19-7683



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-341
Job Sheet 195716



Part No: D206-642-341

Job Qty: 1 pcs

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 Ecn14-520 DD ver: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	7/5/19		0.00	3.23	Skidtubes - 1		RD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
115	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS 24 9-89	JUN 27 2019
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 9	1 pcs	7/5/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24 9-89	JUN 27 2019
							QC 9 - 43		
							QC 9 - 50		



Container No: S193838



Part: D206-642-341

Job No: 195716

Serial No/Batch: S193838

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/04/17, TGA STC SH98--4 Issue 2, EASA STC

Dart Aerospace Ltd.
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CANADA
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Plex 5/30/19 9:08 AM Dart.Guerin.Kimberley

120 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.50	QC 9 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
125 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	

130 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 3.23	QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
140 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
150 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 3.23	QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.23	Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	

210 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10				
				QC 3 - 13				
				QC 3 - 15	Jul 19-7-24			
				QC 3 - 17				
				QC 3 - 18				
				QC 3 - 2				
				QC 3 - 28				
				QC 3 - 3				
				QC 3 - 30				
				QC 3 - 34				
				QC 3 - 36				
				QC 3 - 41				
				QC 3 - 51				
				QC 3 - 58				
				QC 3 - 59				
				QC 3 - 68				
				QC 3 - 9				
				QC 3 - 40				
				QC 3 - 19				
				QC 3 - 43				
				QC 3 - 24				
220 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 5.00	Handfinish - 4 - 1 - B4B	Jul 19-7-23			
				Handfinish - 4 - 10 - B4B				
				Handfinish - 4 - 11 - B4B				
				Handfinish - 4 - 12 - B4B				
				Handfinish - 4 - 13 - B4B				
				Handfinish - 4 - 14 - B4B				
				Handfinish - 4 - 15 - B4B				
				Handfinish - 4 - 2 - B4B				
				Handfinish - 4 - 3 - B4B				
				Handfinish - 4 - 4 - B4B				
				Handfinish - 4 - 5 - B4B				
				Handfinish - 4 - 6 - B4B				
				Handfinish - 4 - 7 - B4B				
				Handfinish - 4 - 8 - B4B				
Handfinish - 4 - 9 - B4B								
230 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10				
				QC 3 - 13				
				QC 3 - 15				
				QC 3 - 17				
				QC 3 - 18				
				QC 3 - 2				
				QC 3 - 28				
				QC 3 - 3				
				QC 3 - 30				
				QC 3 - 34				
				QC 3 - 36				
				QC 3 - 41				
				QC 3 - 51				
				QC 3 - 58				
				QC 3 - 59				
				QC 3 - 68				
				QC 3 - 9				
				QC 3 - 40				
								DAS 40 9-89
								JUL 26 2019
								Plex 5/30/19 9:08 AM Dart.Guerin.Kimberley

240 QC 5	1 pcs	7/5/19	0.00 0.00	QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
255 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
260 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21	

DAS
40
9-89DAS
28
9-89

AUG 02 2019

AUG 02 2019

fg deck

pcs

QC 21 - FG - 70

QC 21 - FG - 53

Part Op 110 - Skid tubes - 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 A/R 5-Cut

Descriptions: aft end to length as per dwg D2650 6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 8-Open Aft Cap Hole using #6 Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail 10-Remove inner indexing ridge on aft end of skid tubes as per Dwg D2650 11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 12-Deburr.

AK
M130989
M139011

115 - QC5- Inspect part completeness to step on W/O

116 - QC9- Inspect visual per QSI004- Fusion Welds

120 - Chemical Conversion Coat per QSI005 4.1

125 - QC7-Inspect Chemical Conversion Coat

130 - Skid tubes 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

140 - QC5- Inspect part completeness to step on W/O

150 - Skid tubes - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 2- Install nut plate as per dwg

180 - QC5- Inspect part completeness to step on W/O

190 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: FINISH TIME:

210 - QC3- Inspect Part Finish

220 - HandFinish4 (Assemble as per dwg - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. 2- Apply RTV 598 on the plugs Batch: 5138467

230 - QC3- Inspect Part Finish

240 - QC5- Inspect part completeness to step on W/O

250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG107

255 - Document Control - Photocopy bluefile and create labels per PPP D206-642-341 CHG005

260 - QC21- Final Inspection - Work Order Release - 7 -Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Job BOM

Part / Item	Component Name	Quantity	Operation
D2620	Skid tube, 206 Skid tube	1 pcs (1 ea)	110-Skid tubes - 1
D2647	Cap	1 pcs (1 ea)	110-Skid tubes - 1
D2654-5	Web	1 pcs (1 ea)	130-Skid tubes - 2 - B4B
D4720-1	Spacer	19 pcs (19 ea)	150-Skid tubes - 3 - B4B
ALS4-1032-130	Rivnut	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
D2651-1	Plug	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B
D2651-3	O-Ring	14 pcs (14 ea)	220-Handfinish - 4-1-Assembly-B4B
D2680-041	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
D3537-1	Wearpad	6 pcs (6 ea)	220-Handfinish - 4-1-Assembly-B4B
D3537-3	Wearpad	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
D4956-11	Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
D4956-35	Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B
MS27039C1-08	Screw	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer	54 Ea (54 ea)	220-Handfinish - 4-1-Assembly-B4B
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B

011075

Container

5189572

5166078

5123849

5123039

5054257

51113767

5160607

5196041

5027457

5197646

5195622

5183621

5179847

5171527

5172571

510092

5166974-1

5167302

5193131

5172370

5058652

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	4	0
	D2647	1	43	0
130-Skidtubes - 2 - B4B	D2654-5	1	11	0
150-Skidtubes - 3 - B4B	D4720-1	19	222	0
220-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	54	7,594	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2646	1	33	0
	D2651-1	14	95	0
	D2651-3	14	304	0
	D2680-041	1	11	0
	D3537-1	6	68	0
	D3537-3	1	18	0
	D4956-11	1	9	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	MS27039-1-08	2	467	0
	MS27039-4-06	1	95	0
	MS27039C1-08	54	477	0
	NAS1149C0332R	54	3,404	0
	NAS1149D0332J	2	3,596	0
	NAS1149D0463J	1	3,447	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 9:08 AM Dart.Guerin.Kimberley

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN980JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL .20.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

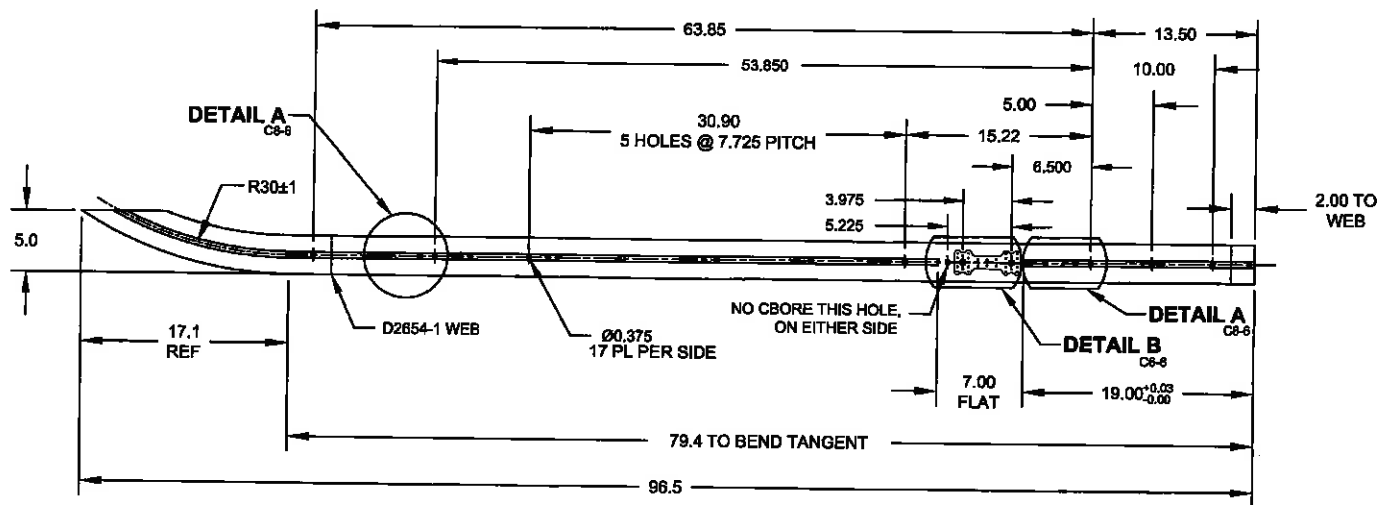
DEO ATTACHED
RELEASED
08.08.08

DESIGN	DS	DATE
DRAWN	AJS	08.08.08
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.08.08	

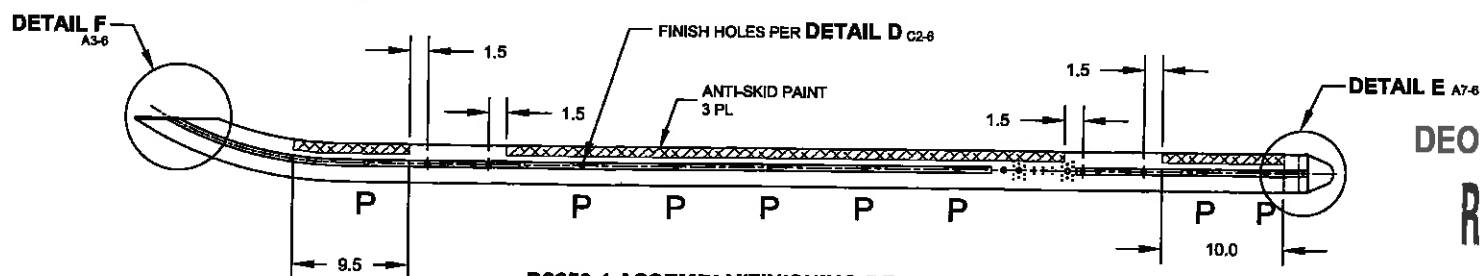
REV.	DESCRIPTION	BY	DATE
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 238).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.28
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2650	SHEET 1 OF 6
TITLE	SCALE
206/407 SKIDTUBE ASSEMBLIES	NTS

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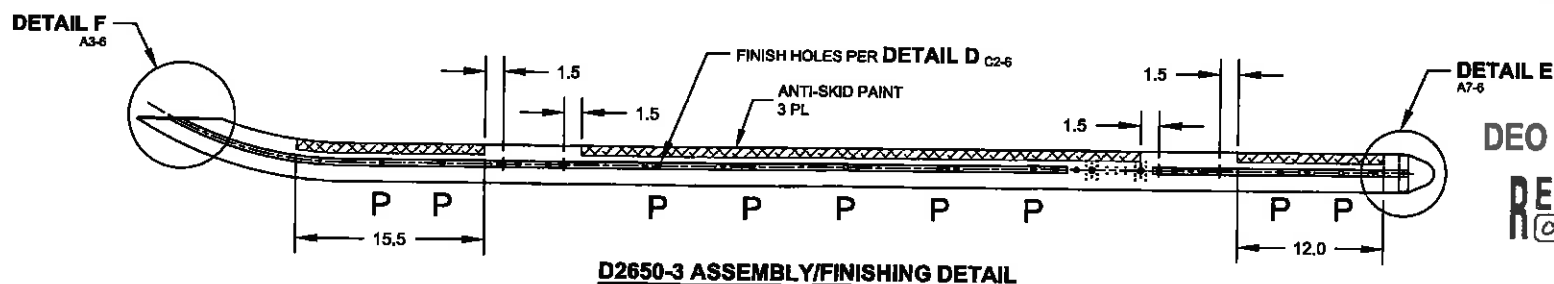
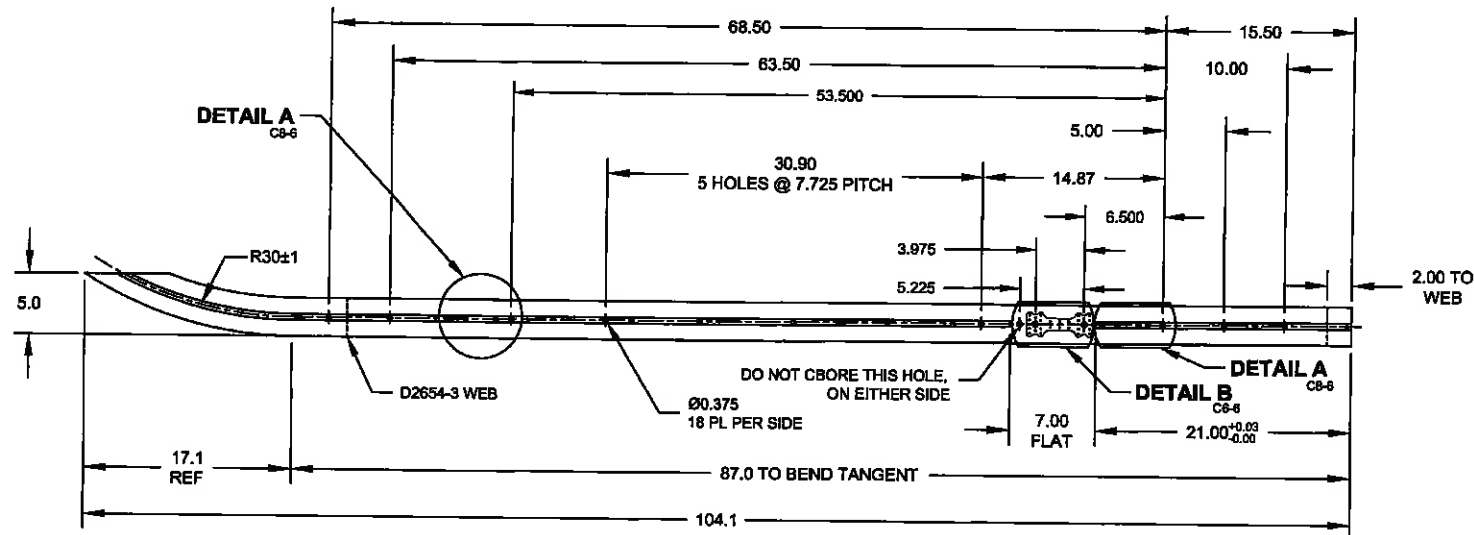
D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

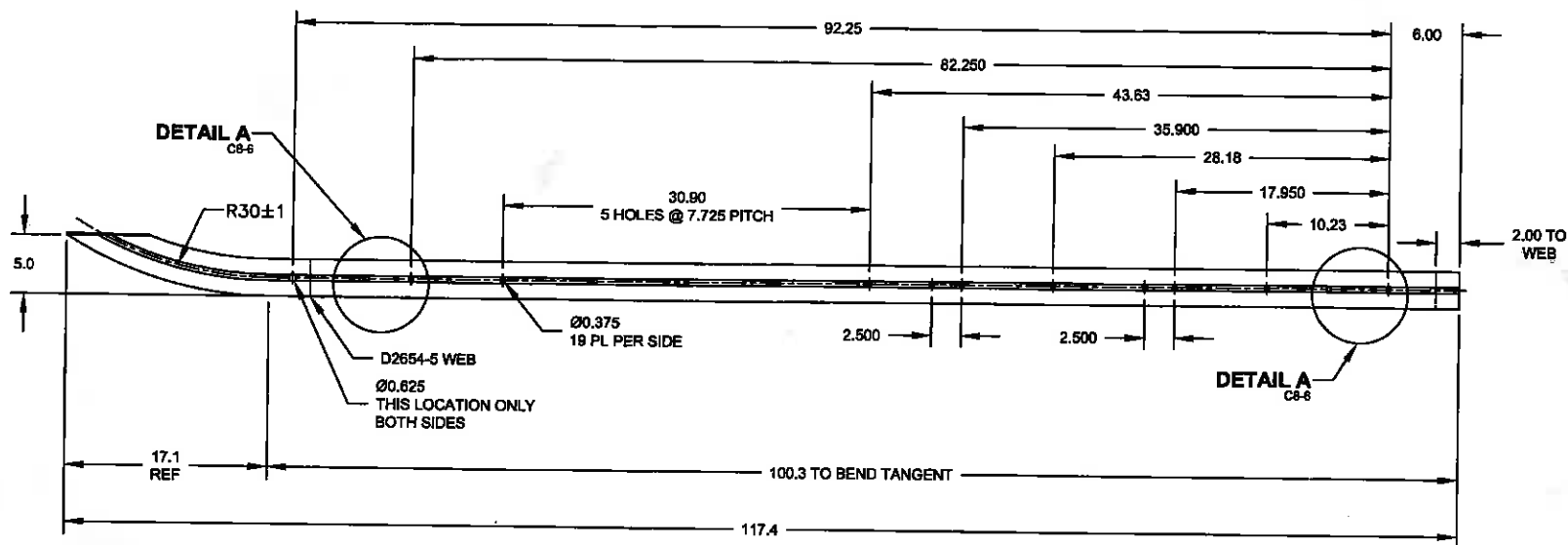
DEO ATTACHED
RELEASED
680922/111

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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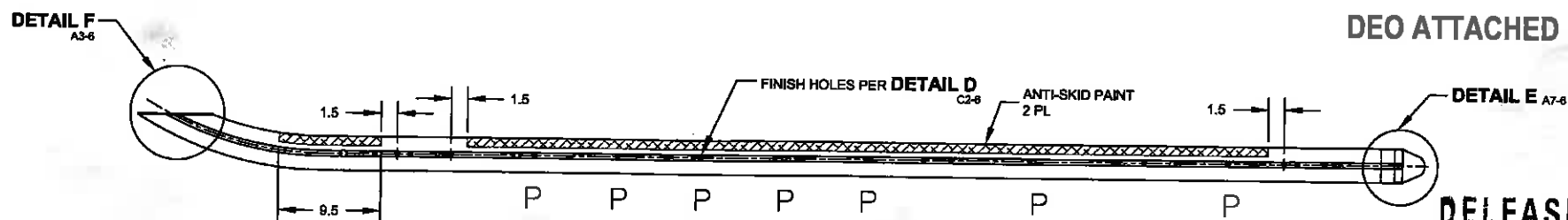


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08 07 22 118

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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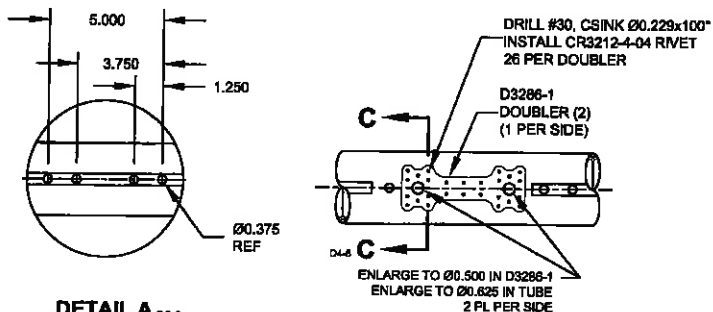
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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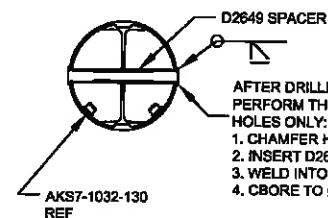
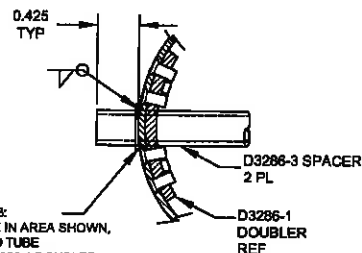
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5

DETAIL B
SCALE 2X
C3-2
C3-3

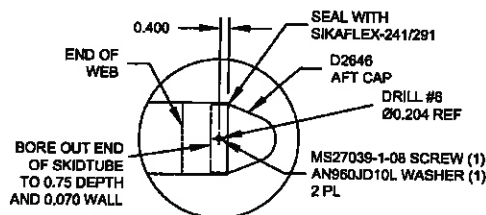
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



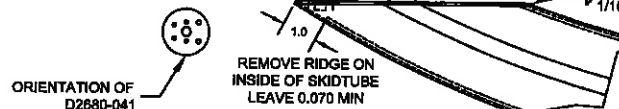
SECTION C-C C7-6
SCALE NONE



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-2013

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

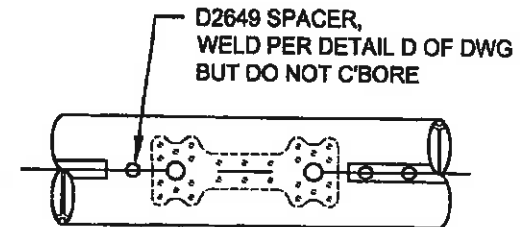
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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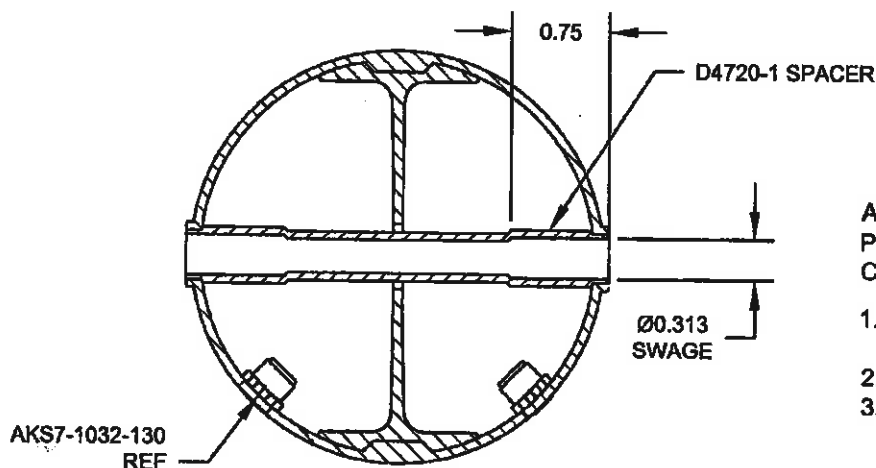
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

